



Dart Aerospace Ltd.
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Hawkesbury, ON
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Tel (613) 632-5200

C3-19C

Job Sheet 175311



Part No: C3-19C

Job Qty: 1 ea

Part Name: C3 Cage



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/2/18

Job Tracking No:

Due Date: 4/13/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG C3-19C Rev 5 IPP Rev A 18.03.29 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		4/12/18	0.00	0.00	Start Up Large Fab-7		EL
100	Large Fab	1 pcs		4/12/18	0.00	10.00	Large Fab 8		EL
110	QC	1 pcs		4/12/18	0.00	0.00	QC9		PD 13-04-10
120	QC	1 pcs		4/12/18	0.00	0.00	QC5		PD 18-04-10
130	Powdercoat	1 pcs		4/13/18	0.00	0.50	Powdercoat6		BL 18-4-12
140	QC	1 pcs		4/13/18	0.00	0.00	QC3		SA
150	Packaging	1 pcs		4/13/18	0.00	0.00	Packaging3-2		SA
160	QC21-SA	1 Ea		4/13/18	0.00	0.00	QC21		APR 13

Part Op 100 - 1-MANUFACTURE AS PER DWG, TACK WELD FOR INSPECTION BY: _____ USE WELDING JIG C3-19C.

Descriptions: 2-Weld as per DWG. ***SEE NOTE 1, ALL HOLES MUST ALIGN***

130 - START TIME: 3:35 OVEN TEMPERATURE: 350° FINISH TIME: 4:05

M 174273.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-A513-T-0.8750W0.120	A513 Seamless Alloy Steel Round Tubing 0.875"dia. x 0.120" Wall	11.5000 ft (11.5 ea)	90-Start up Operation	
C3-18-1	Lifting Plate	2 Ea (2 ea)	100-Large Fab	
C3-18-5	Boss	2 Ea (2 ea)	100-Large Fab	
C3-18-6	Bumper Bracket	1 Ea (1 ea)	100-Large Fab	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MT-A513-T-0.8750W0.120	12	60	0
100-Large Fab	C3-18-1	2	0	0
	C3-18-5	2	0	0
	C3-18-6	1	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Quality ☐ Other ☐																																										
Date : _____ Step #: _____		Container No: S059560 Part: C3 - 19C Job No: 175311 Serial No/Batch: S059560 Revision: 5 Inspector: _____ Date: 04/10/18																																										
Description Work Order Deviation																																												
<table border="1" style="width:100%; border-collapse: collapse;"> <thead> <tr> <th colspan="3" style="text-align: left;">Root Cause</th> </tr> </thead> <tbody> <tr> <td style="width:15%;">Environment</td> <td style="width:15%;">☐</td> <td style="width:15%;">No Re-verification</td> </tr> <tr> <td>Design</td> <td>☐</td> <td>Operator</td> </tr> <tr> <td>Doc/Data</td> <td>☐</td> <td>Offset/Setup</td> </tr> <tr> <td>Equip/Tooling</td> <td>☐</td> <td>Supplier</td> </tr> <tr> <td>Handling/Pre</td> <td>☐</td> <td>Training</td> </tr> <tr> <td>Material</td> <td>☐</td> <td>Use for Testing</td> </tr> <tr> <td>Internal Transport</td> <td>☐</td> <td>Poor Information</td> </tr> <tr> <td>Tribal Knowledge</td> <td>☐</td> <td>Rushing</td> </tr> <tr> <td>LOA</td> <td>☐</td> <td>Product Improvement</td> </tr> <tr> <td>Substation</td> <td>☐</td> <td>Process Improvement</td> </tr> <tr> <td>Past Expiry Date</td> <td>☐</td> <td>Manufacturing Process</td> </tr> <tr> <td>Misidentified</td> <td>☐</td> <td>Past Due</td> </tr> </tbody> </table>						Root Cause			Environment	☐	No Re-verification	Design	☐	Operator	Doc/Data	☐	Offset/Setup	Equip/Tooling	☐	Supplier	Handling/Pre	☐	Training	Material	☐	Use for Testing	Internal Transport	☐	Poor Information	Tribal Knowledge	☐	Rushing	LOA	☐	Product Improvement	Substation	☐	Process Improvement	Past Expiry Date	☐	Manufacturing Process	Misidentified	☐	Past Due
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Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐			Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐			Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐			Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐																																			
OTHER : _____																																												